

EXHIBIT N

P. O. BOX 8

815-469-2335

ASSEMBLY ORDER FOR PRESS BRAKE

Recd. 1/11/78 MODEL NO. 10-1 SERIAL NO. 2475 DUE DATE 3/15/78

D. T. O'NEAL MACHINERY CO.

P.O. NO. 13

PTO: AYCO LYCOMING DIVISION, 550 South Main St., Stratford, Conn. 06497

PRESS BRAKE TO INCLUDE

BASE PRICE	Specifi- cation		Specifi- cation		Specifi- cation	
ROKE	3		RAM INDICATOR	YES	COUNTER	NO
UT HEIGHT	12		RAM POWER	YES	BALANCE	NO
TOR HP	5		HORN EXT. RIGHT	NO	RAM MACHINE	NO
TOR RPM	3400		LEFT	NO	FOR ANGLES	NO
TOR FRAME			LUBRICATION		BED MACHINE	NO
			ONE SHOT	YES	FOR ANGLES	NO
			AUTOMATIC	NO	WELDED ANGLES	NO
			TRU-KON-TROL		PERMANENT	NO
			PRESS BRAKE	YES	FLANGED BED	NO
			TRU-KON-TROL		PERMANENT	NO
ULLEY			PUNCH PRESS	NO	FLANGED RAM	NO
ARTER STD.	YES		PALM BUTTONS	NO	CAST BRACKET	NO
REV	NO		FOOT SWITCH	YES	BOLSTER PLATE	NO
LTAGE	440 V		BACK GAUGE, FRONT		DIE BLOCK	YES
			OPER. MANUAL	YES	PAINT	STD.
			POWER	NO		

OPTIONAL EQUIPMENT

THIS ORDER IS SUBJECT TO CANCELLATION CHARGES

[illegible]

STARKS


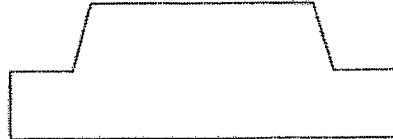
Order is accepted subject to the right of the purchaser to cancel the same at any time prior to shipment upon written notice to this company of such cancellation and payment of a cancellation charge of twenty per cent of the total amount of the order. If such notice is received within fifteen days from the date of the order such cancellation charge will be waived.

Completed By Date Shipped By

lex: MA=Machine for angles H=Horn Press PF=Permanent Flange

IN RECTION SHEET PRESS BRA

Date	Model No. 90-6	Serial No. 2176				
Item	Check	Spec./Comment	OK By	Objection	Correction	OK By
Stroke	Dim. inches	3"	B7			
Shut Height	Ram to bed strk dn-adj. up	12"	OK			
Strokes/minute	Actual count	25 strokes	OK			
Flywheel	Exact dia. and thickness	24" x 3 1/2"	B7	✓	OK by WALLY + B Ramsay	
Flywheel Rotation	Clockwise/counterclockwise	C.C.W.	B7			
V-Belts	Section size and length	B-85	B7			
V-Pulley	O.D. and bore	4460-80	B7			
Ram Adj. Up	Actual ram indicator reading	6.0180	OK			
Ram Adj. Down	Actual ram indicator reading	6.500	OK	✓		
Ram and Bed Alignment	Clamp bar on each end bring ram down and measure	L. 5, 5 1/16 R. 5 1/16, 5 1/16	OK			
Lubricator	Make and size	Bijon one shot	B7			
Lube Type	Kind of oil or grease used	3 Lubricant 21	B7			
Oil Meters (Ram Guides)	Actual size	#1	B7			
Oil Meters (Conn. Rods)	Actual size	#3	B7			
Meters (Main Brngs)	Actual size	#2	B7			
Oil Lines	Purged and fittings tight	OK	B7			
C'bal. Cylinders	Bore and stroke	NA	B7			
C'bal Cyl. Bar	Size and length	NA	B7			
C'bal Cyl. P.S.I.	Press. req'd to take up ram	NA	B7			
C'bal Pressure Sw.	P.S.I. set @	NA	OK			
Main Pressure Sw.	P.S.I. set @	72 PSI	OK			
Clutch Hub	Bore & thickness	2 1/8" x 3"	B7			
Clutch Hub Lock	Type and tightness	nut & lock ring	B7			
Clutch Plates	Quantity and size	3 plate	B7			
Clutch Shims	Quantity and thickness	2 per pin	B7			
Clutch Operation	Friction and heat	OK	OK	✓		
Brake Hub	Shape, bore and thickness	2" x 2 1/8"	B7			
Brake Disc	Bolts, runout and concentricity	3 bolts	B7			
Brake Caliper(s)	Quantity bolts and run out	one	B7			
er Mtg. Bolts	Dia, length and head clearance	1" x 2; 1/2 clearance	B7			
Dis Block	Position in groove and size	standard	B7			
Horn, Extension(s)	Length and R and/or L	NA	B7			

Item	Check	Spec./Comment	OK	By	Objection	Correction	OK	By
Operat. Back Ga.	Type required				BACK ORDERED			
Machine For Angles	Bed and/or ram	N/C		ck				
Motor H.P. and RPM	From nameplate	5HP: 3495						
Motor Volt and Frequency	From nameplate	220-440V			✓			
Motor Starter	Make size and type	900520 M.L.C.			✓			
Heater Relays	Size Number	630T37			✓			
Circuit Breaker	Make, amps and volt rating	15A 600V			✓			
Press Controls	Quantity and type of oper. stations	1 floor			✓			
Press Control Specs	Location and type of connection	FLOOR			✓			
Motor Wiring	Wire size	#14			✓			
Motor Start-Up	Time req'd for full flywheel rpm	7 seconds			✓			
Elect. Dwg. Used	Dwg. number and date	D-7607			✓			
Cams	Setting all modes and rotation	S.T.P. AUG 1970			✓			
Lube Cycle	Actual time and oil amount	0.50			✓			
in Bearings Clearance	Jack up ram with knuckle tight (loosen it after check)	.015			✓			
Knuckle Clearance	Use feeler gauge & lock upper nut	.003			✓			
Special Features and Notes								
Location	Left	Right						
Ram	Bottom .000	.000						
	Up .000	+ .005						
	Down .000	- .005						
								
				ck				